

DART AEROSPACE LTD		Work Order:	20962
Description: Spacepod Hardware Kit		Part Number:	K10018
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C TP 03.04.30		Qty:	2 Kits
			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: K10018 Kit to be made in multiples of 7.</b> (1) K10018 requires (2) D2174-041. (1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle	HF	04.06.01	2
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2174-1</b> Batch:			
3	MV	<b>Cut (2) blanks per (1) K10018 Kit</b> Cut blanks: (12.200" x 2.960") <b>grain along 2.960</b> Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) <b>Use stack of 7</b> <b>Identify for D2175</b> Batch:			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 <b>Identify as D2174-1</b>			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 <b>Identify as D2175</b>			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 <b>Pick:</b> Qty Part Number Description Batch 23 MS20470AD4-6 Rivet <b>Identify as D2174-041</b>			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries  
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	20962
Description: Spacepod Hardware Kit		Part Number:	K10018
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C		Qty:	1 <del>100</del> Kits
RF 03.04.30		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty
21	KP	Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3)			
		Qty Part Number Description Batch			
		2✓ D2174-041 Web Assembly B3571/B13507			
		1✓ D2985 Decal B14160			
		8 A3235-020-935 Washer			
		16✓ AKS71032-130 Insert m14240			
		8✓ AN3-3A Bolt m4824			
		8✓ AN3H4A Bolt (or AN3H4) m14149			
		36✓ AN525-10R7 Screw m14940			
		8✓ AN960JD10 Washer m14318			
		16✓ AN960JD10L Washer m14312			
		16✓ MS21042L3 Nut (or -3) m14478			
		8✓ MS24694S67 Screw m9750			
22	QC4	Inspect Kit 100% for Completeness on the W/O		04/06/17	2
23	ST	Identify and Stock		04/06/17	2
24	AC	Cost / part 38.52		04-06-18	2
25	DC	Close W/O 50.27 Inspect Level 21		09/07/02	2

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	#

RELEASED  
03.04.30

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

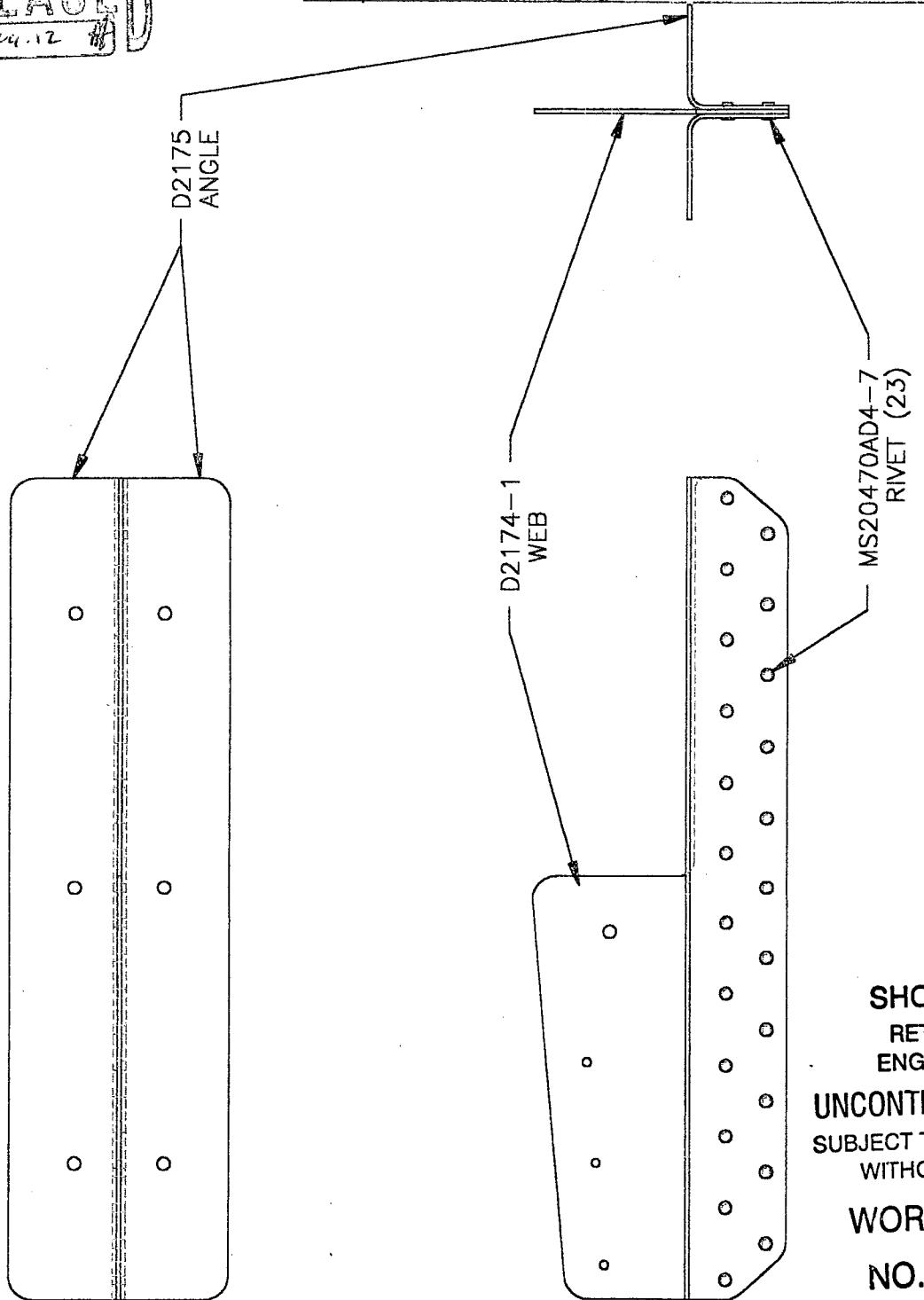
NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
		Initial							

PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN B. WILLIAMS	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>Bru</i>	APPROVED <i>RF</i>	DRAWING NO. D2174-041 <i>RF 00.07.06</i>
DATE 95:10:25		SCALE SHEET 1 OF 1
		TITLE WEB ASSEMBLY
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC. <i>RF CP</i>

RELEASED  
00.04.12 *RF*



*AC*

MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK  
FINISH: ANODIZE CLEAR Powder coat white PEC DRAFT Q527 005 4.3.5.1

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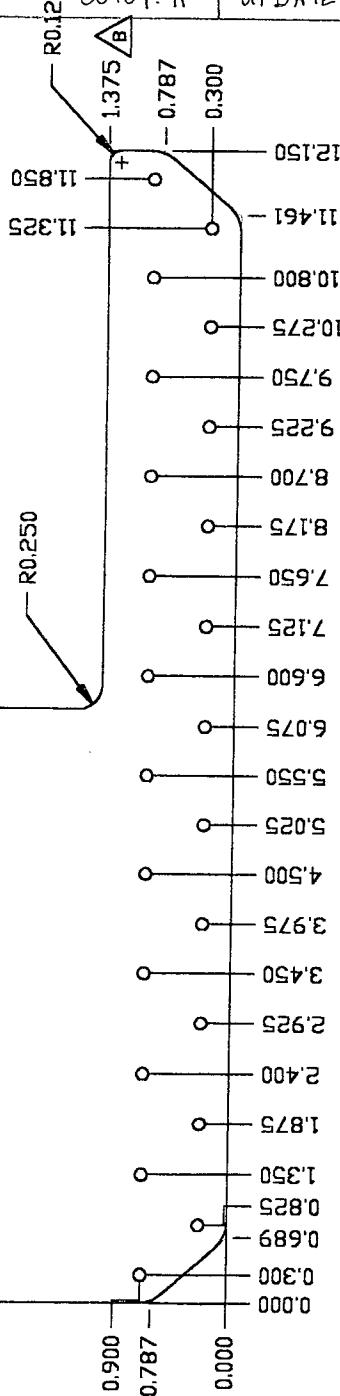
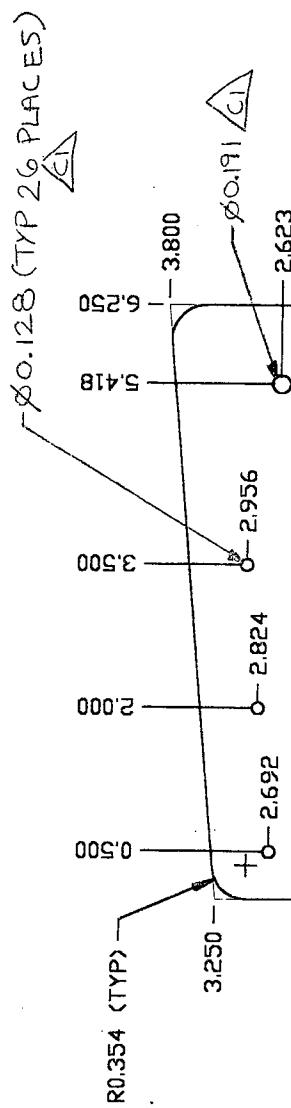
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WITHOUT NOTICE

WORK ORDER  
NO. 20962



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B. WILLIAMS	K. HAND		
CHECKED	APPROVED	DRAWING NO.	REV. 4
B. Williams		D2174-1	
DATE		TITLE	SHEET 1 OF 1
95.10.25		WEB	SCALE
B	96.01.18	RE-DRAWN CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. <i>CP</i>	

RELEASED  
00.09.12 *CP*



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WORK ORDER

NO. 20962



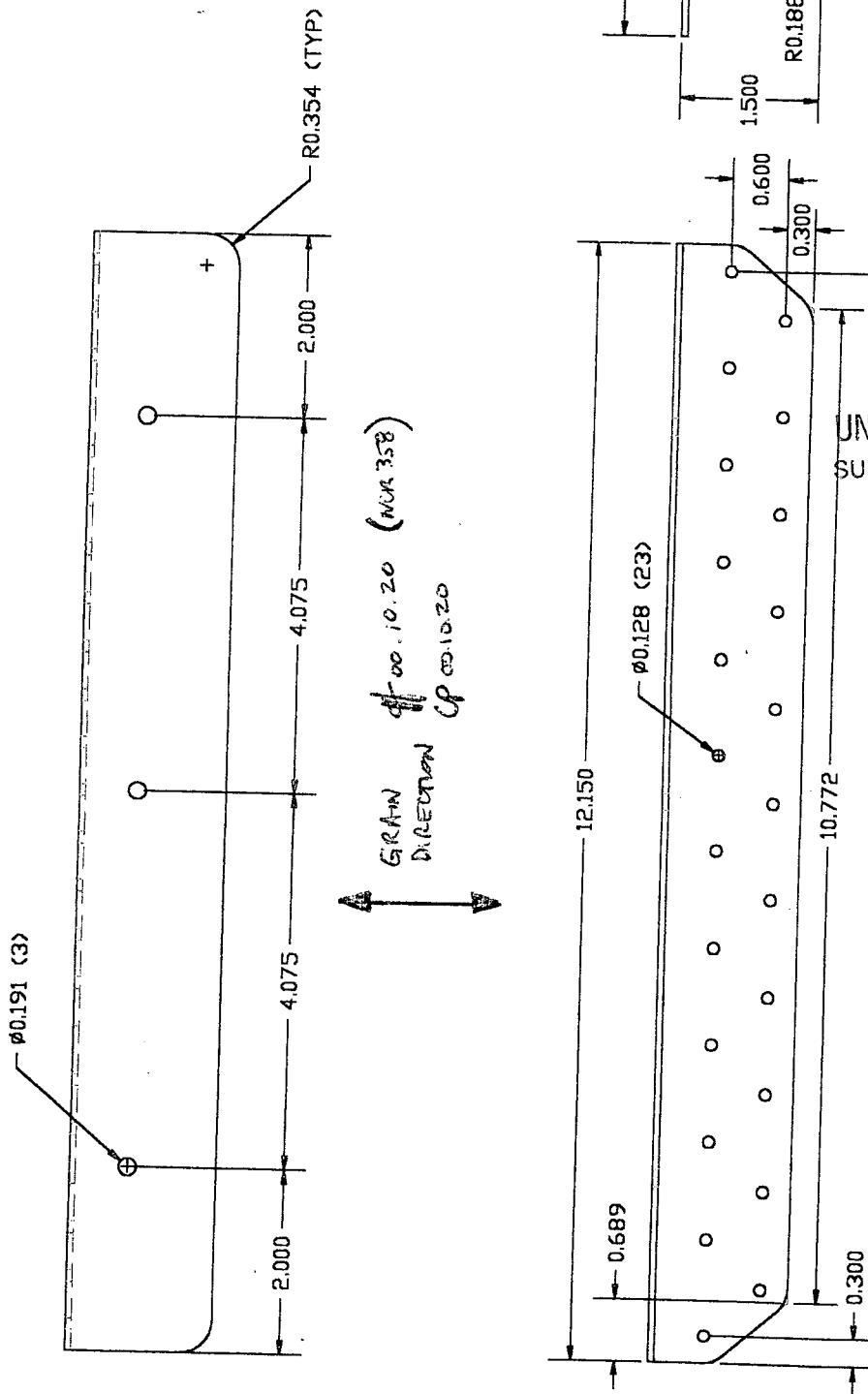
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
MATERIAL: 2024-T3 (QQ-A-250/5), 0.063 THICK

C1 01.02.22 ADD HOLE DIMENSIONS *CP*



00.09.12 4

DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED/ <i>BW</i>	APPROVED <i>SH</i>	DRAWING NO. D2175	REV. A SHEET 1 OF 1
DATE 95:10:25	TITLE ANGLE		SCALE
B	96.01.18	CHANGED DIMENTION	
C	00.09.11	UPDATE FINISH SPEC. <i>SH GP</i>	



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WITHOUT NOTICE

WORK ORDER  
NO. 20962

MATERIAL: 2024-T3 (QQ-A-250/57, 0.063 THICK  
FINISH: ANODIZE CLEAR. CHEMICAL CONVERSION COAT P.E.  
QST BOS 4.

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 01, 2004  
01:56 pm

Work Order No : 0020962  
 Project Name : K10018  
 Project For : WK426  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : K10018  
 Description : Spacepod Hardware Kit  
 Manufactured : Yes  
 Amount Req'd : *✓*  
 Amount Done : 0  
 Start Date : 06-01-04  
 Est Finish Date : 06-24-04  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
*✓*

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00